

Date: Friday, 5/19/2006 10:03:19 AM
 User: Linda Lacelle

Process Sheet

Split 060601

Customer : CU-DAR001 Dart Helicopters Services Drawing Name : BRACKET ASSEMBLY
 Job Number : 27178 -1
 Estimate Number : 10679
 P.O. Number : N/A Part Number : D3155041
 This Issue : 5/19/2006 S.O. No. : N/A Drawing Number : D3155 REV C
 Prsht Rev. : NC Project Number : N/A
 First Issue : N/A Type : MACHINED PARTS Drawing Revision : C
 Previous Run : 25282 Material : N/A
 Due Date : 6/2/2006 Qty: 13 Um: Each
 Written By : SEE COMMENTS BELOW
 Checked & Approved By : SEE ABOVE USER & DATE
 Comment : Est B 03.02.03 Reformat KJ/RF

Additional Product

Job Number:



Seq. #: Machine Or Operation: Description :

1.0 M6061T6B1000X02000 6061-T6 Bar 1.0" x 2.0"



Comment: Qty.: 0.6125 f(s)/Unit Total: 6.1247 f(s)
 Material: 6061-T6-T651 (QQ-A-200/8 or QQ-A-225/8)
 (M6061T6B2.000x01.000)
 Batch: M101000

SD 06.05.20

2.0 BAND SAW BAND SAW



Comment: BAND SAW
 Cut blanks: (2.000" x 1.000") x 6.87" Long Bar

SD 06.05.20

3.0 HAAS1 HAAS CNC VERTICAL MACHINING #1



Comment: HAAS CNC VERTICAL MACHINING #1
 1-Machine as per Folio FA315 and Dwg D3155
 2-Deburr and Tumble

SD 06.05.20

4.0 QC2 INSPECT PARTS AS THEY COME OFF MACHINE



Comment: INSPECT PARTS AS THEY COME OFF MACHINE

SD 06.05.20

P10
 See p to
 on original

Process Sheet

Customer: CU-DAR001 Dart Helicopters Services

Drawing Name: BRACKET ASSEMBLY

Job Number: 27178

Part Number: D3155041

Job Number:



Seq. #: Machine Or Operation: Description :

5.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-06-01 (10)

6.0

HAND FINISHING1

HAND FINISHING RESOURCE #1



Comment: HAND FINISHING RESOURCE #1

Chemical Conversion Coat as per QSI 005 4.1

SAD 06:06:01 (20)

7.0

QC3

INSPECT POWDER COAT/CHEMICAL CONVERSION



Comment: INSPECT POWDER COAT/CHEMICAL CONVERSION

06-06-01 (10)

8.0

D31553

Bushing



Comment: Qty.: 2.0000 Each(s)/Unit Total : 20.0000 Each(s)

Bracket Assembly

Qty	Part number	Description	Batch
2	D3155-3	Bushing	<i>524244</i>

SAD 06:06:01 (10)

9.0

SMALL FAB 1

SMALL & MEDIUM FAB RESOURCE 1



Comment: SMALL & MEDIUM FAB RESOURCE 1

Press fit bushing as per Dwg D3155

SAD 06:06:01 (10)

10.0

QC5

INSPECT WORK TO CURRENT STEP



Comment: INSPECT WORK TO CURRENT STEP

06-06-01 (10)

11.0

PACKAGING 1

PACKAGING RESOURCE #1



Comment: PACKAGING RESOURCE #1

Identify and Stock

Location: *Space door / Comp Assy*

06-06-01 (10)

12.0

DC

DOCUMENT CONTROL



Comment: DOCUMENT CONTROL

Inspection Level 21

06/06/02 (10)

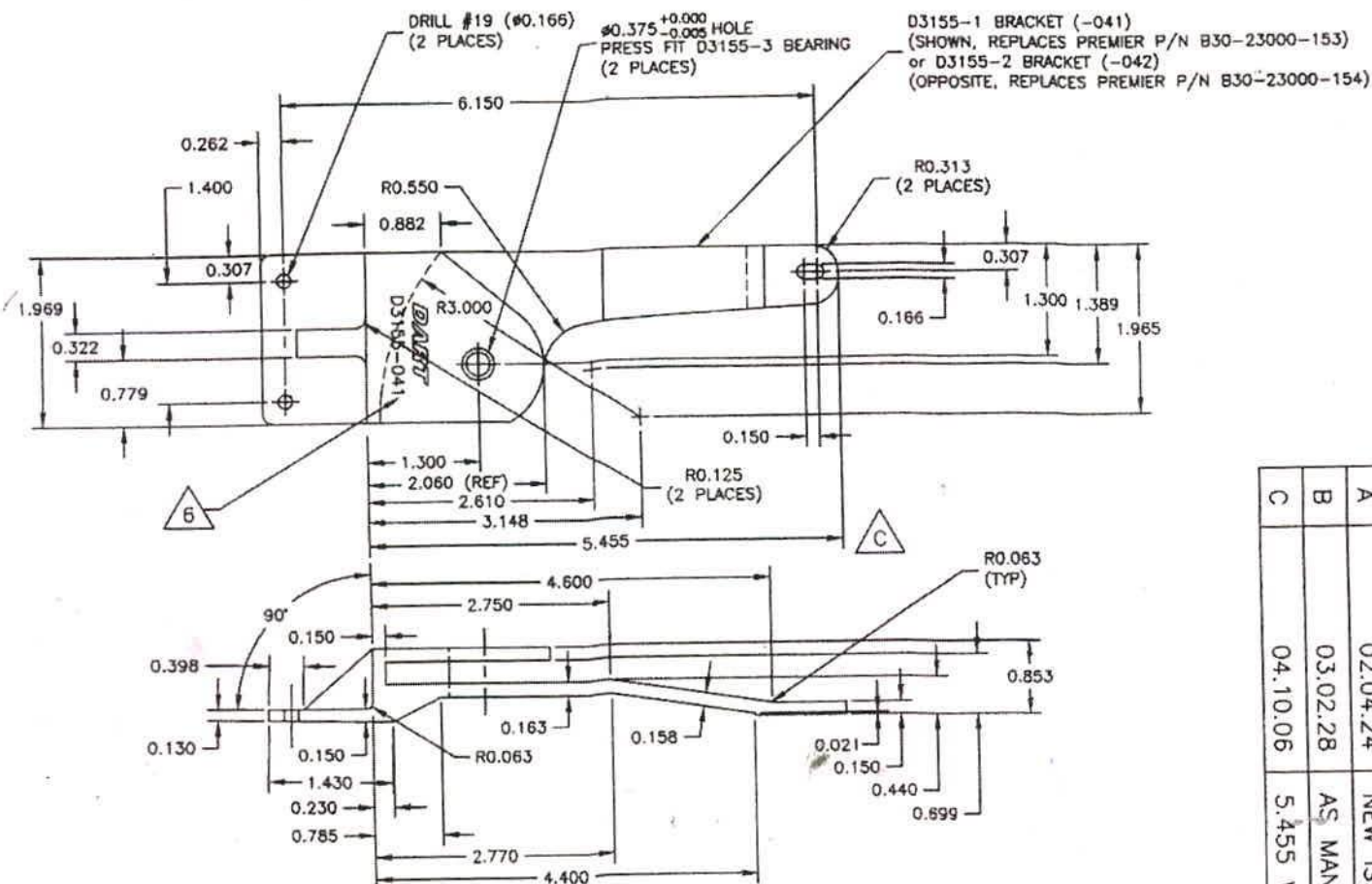
Job Completion



06-06-02

DART

DESIGN	DRAWN BY	DART AEROSPACE LTD
		HAWKESBURY, ONTARIO, CANADA
CHECKED	APPROVED	REV. C
DATE	TITLE	SHEET 1 OF 2
04.10.06	BRACKET ASSEMBLY	SCALE 1:2
A	02.04.24	NEW ISSUE
B	03.02.28	AS MANUFACTURED
C	04.10.06	5.455 WAS 5.550

**D3155-041 BRACKET ASSEMBLY**

(SHOWN, REPLACES PREMIER P/N B30-23000-11)

D3155-042 BRACKET ASSEMBLY

(OPPOSITE, REPLACES PREMIER P/N B30-23000-12)

D3155-1/-2 BRACKET

- 1) MATERIAL: 6061-T6/-T651 (QQ-A-200/8 OR QQ-A-225/8) BAR (REF DART SPEC. M6061T6B)
- 2) FINISH: CHEMICAL CONVERSION COAT PER DART QSI 005 4.1
- 3) TOLERANCES ARE PER DART QSI 018 UNLESS OTHERWISE NOTED
- 4) ALL DIMENSIONS ARE IN INCHES
- 5) BREAK ALL SHARP EDGES 0.005 TO 0.015
- 6) ENGRAVE DART P/N & LOGO AS SHOWN

REFERENCE ONLY**RELEASED**
04/11/23

Work Order:

27178

Part Number:

3155-041

Page 1 of 1

FIRST ARTICLE INSPECTION CHECKLIST

☒ First Article☐ Prototype

	tolerance	Actual Dimension	Accept	Reject	Method of Inspection	Comments
Ø.166		Ø.167	/			
.262		.262	/			
1.400		1.401	/			
.307		.314	/			
.322		.325	/			
1.969		1.969	/			
.779		.776	/			
.882		.878	/			
2.060		2.059	/			
1.300		1.298	/			
Ø.375	+ .000 - .005	Ø.375	/			
1.300		1.310	/			
1.965		1.968	/			
.166		.165	/			
.307		.314	/			
.398		.398	/			
.130		.128	/			
.150		.155	/			
.150		.148	/			
2.750		2.755	/			
4.600		4.603	/			
.853		.847	/			

SD

06.05.20

Audited by:

J.F

Date:

06/05/21

Prototype Approval:

Date:

N/A

Revised by

Approved

KJ:RF